

Work Order ID 70045

Wednesday, May 25, 2011 3:10:41 PM



Page 1

Item ID: D206-802-029

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, LH

Start Date: 5/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/05/25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-3

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-029 CHG001

to 8/11/05/27

JF for BG 11-5-26
②

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB / 11/05/27 ②

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/11/05/27

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPDD206-802-029

Location:

PPP rev: PPDDRun of 2 - 2

130

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/5/31MF11-05-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 70045

Parent Item: D206-802-029

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/25/2011


Required Date: 5/31/2011

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15  Door Prop		Manufactured	No			105	Each	27.0000	1	2 ✓			
------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	---	-----	--	--	--

Location	Loc Qty	Loc Code
ST272	15	
64402	15	64402
ST272A	12	
65119	12	

D3622-5  Ball Stud		Manufactured	No			105	Each	48.0000	1	2 ✓			
-----------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	---	-----	--	--	--

Location	Loc Qty	Loc Code
ST070	48	
64330	8	64330
64428	20	
65087	20	

D4110-3  Doubler, Sill		Manufactured	No			105	Each	9.0000	1	2 ✓			
-----------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	-----	--	--	--

Location	Loc Qty	Loc Code
ST130	9	
64356	4	64356
64788	5	

JB 11/05/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 70045

Parent Item: D206-802-029

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

D4114-1 Manufactured No

105 Each

2.0000

1

2

✓



Door Doubler, LH

Location

Loc Qty

Loc Code

ST130

2

64498

2

64498

MS20426AD4-5

Purchased

No

105

Each

5,772.000

4

8



Rivet

Location

Loc Qty

Loc Code

MEZZ

483

6733

483

6733

ST317

5289

6874

5289

MS20600-AD4W2

Purchased

No

105

Each

300.0000

32

64

✓



Rivet

Location

Loc Qty

Loc Code

ST321

300

116391

5

116471

4

116805

35

117317

56

117601

150

117739

50

116805X19

117601X45

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D206-802-029

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

MS21073L5

Purchased

No

105

Each

141.0000

2

4

✓



nut plate

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

41

113660

21

116583

20

113660

JB

NAS1149C0532R

Purchased

No

105

Each

324.0000

6

12

✓



WASHER

Location

Loc Qty

Loc Code

ST297

324

116289

24

116373

100

116513

200

116513

JB

NAS1149C0563R

Purchased

No

105

Each

550.0000

6

12

✓



Washer

Location

Loc Qty

Loc Code

ST297

550

112532

100

115768

50

116391

200

117460

200

115768

JB

11/05/27

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Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Work Order ID: 70045



Parent Item: D206-802-029



Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

MS27130-A26

Purchased

No

105

Each

77.0000

1

2

✓



Rivnut



JB 11/05/27

Location

Loc Qty

Loc Code

ST293

77

116521

77

116521

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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5.0 PARTS LIST

REFERENCE ONLY

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER